

Work Order ID 141157

141157

January 28, 2016 4:10:10 PM

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Ship March 9/16

Item ID: D206-642-312BL Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube RH, Low & High Gear (Ael Blue)
 Start Date: 1/28/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 3/9/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: SK Date: 6 0 1 2 8 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	Q								
100	Document Control	0.00	DAS						
100	DOCUMENT CONTROL		26						
DC	Memo	0.00	9-89						
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-642-312 CHG008								
									MCS 16-02 01
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MAR 08 2016

FEB 01 2016

MAR 08 2016

B140300

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Item ID: D206-642-312BL

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/9/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-312								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

BAS
27
9-59
MAR 08 2016

MAR 08 2016

MAR 08 2016

sold

ML5

ML5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

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Work Order ID: 141157

141157

Parent Item: D206-642-312BL

***D206-642-312RI ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: J 05.10.11 Added D3429-1 per CHG004KJ/CP/JLM/EC
 IPP Rev: K 07-12-04 ECN 1080p DD verified by: ec
 IPP Rev: L 08-09-29 as per DSI9421 DD verified by: EC IPP
 Rev: M 09-03-02 as per DSI9440 rev.a verified by: EC
 IPP Rev: N 09-03-03 as per DSI9421 rev.b verified by: EC IPP Rev: O
 as per REV.N DD 10.04.19 verified by: EC IPP Rev: P 14.04.25
 ECN14-520 DD verf: JLM IPP REV: Q 15.10.09 ADDED
 BL DD VERF: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-642-341BL		Manufactured	No				Each	2.0000		1			
*D206-642-341RI *													
Replacement Skidtube (Fits LH or RH)													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				2		B140300			DAS 28 9-89
				140301				1					
				140305				1					

D206-648-013BL		Manufactured	No				Each	0.0000		1			
*D206-648-013RI *													
Ground Handling Wheel Modification													
D2932-2BL		Manufactured	No			110	Each	1.0000		1			
*D2932-2RI *													
Saddle RH Out, 206													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST392				1					DAS 28 9-89
				138658				1					

D2933-2BL		Manufactured	No			110	Each	3.0000		1			
*D2933-2RI *													
Saddle RH In, 206													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST389				3					DAS 28 9-89
				138660				3					

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Parent Item: D206-642-312BL

***D206-642-312RI ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

D2938-2BL

Manufactured No

110 Each

3.0000

1

DAS

***D2938-2RI ***

Saddle RH Out, 206

**

26
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST390

3

138659

3

110

Each

2.0000

1

DAS

D2939-2BL

Manufactured No

***D2939-2RI ***

Saddle RH In, 206

**

26
9-89

Location

Loc Qty

Loc Code

ST391

2

139953

2

110

Each

466.0000

8

DAS
28
9-89

AN3-41A

Purchased No

AN3-41A

Bolt

**

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

20

122416

20

over003

314

123355

314

ST347

132

123355

132

110

Each

439.0000

16

16

DAS
28
9-89

D2652

Manufactured No

D2652

Bushing

**

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

45

31985

45

ST009

394

136228

387

136792

7

FEB 04 2016
FEB 01 2016

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Parent Item: D206-642-312BL

D206-642-312BL

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

2,544.000

8

8

MS21042L3

Nut

**

DAS
26
9-89

Location

Loc Qty

Loc Code

CCK007

2000

m134039

2000

FP001

163

m133790

163

GA

195

m133790

195

ST304

186

m133790

186

NAS1149D0363J

Purchased

No

110

Each

1,858.000

8

8

NAS1149D0363J

Washer

**

DAS
26
9-89

Location

Loc Qty

Loc Code

GA

84

m130799

84

ST260a

1000

m134055

1000

ST263

774

m133790

274

m133932

500

DAS
28
9-89

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Work Order ID: 141157

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Parent Item: D206-642-312BL

***D206-642-312RI ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

AN5-10A Purchased No 110 Each 322.0000

AN5-10A

Bolt

**

4 4

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

51

122800

51

over003

200

m133769

50

m134039

150

ST338

71

m133483

71

4X

DAS
27
9-89

AN5-11A Purchased No 110 Each 109.0000

AN5-11A

BOLT

**

4 4

DAS
28
9-89

Location

Loc Qty

Loc Code

over003

50

M134039

50

ST338

59

M133077

9

M133234

50

4X
3X

DAS
27
9-89

DAS
28
9-89

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Work Order ID: 141157

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Parent Item: D206-642-312BL

***D206-642-312BI ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

110

Each

1,410.000

8

8

NAS1149D0563.I

Washer

**

DAS

26

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

GA

53

m125807

53

ST260a

900

m133769

400

m133990

500

ST263

354

m133363

154

m133938

200

ST269

103

m128257

103

DAS
27
9-89

AN4-6A

Purchased

No

110

Each

1,185.000

12

12

AN4-6A

BOLT

**

DAS

26

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

CA

143

M128403

43

M130851

100

over03

1000

M133790

1000

ST345

42

M133316

18

M133363

24

DAS
27
9-89

FEB 02 2016

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Work Order ID: 141157

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Parent Item: D206-642-312BL

***D206-642-312BL ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

5,435.000

24

24

NAS1149D0463.J

WASHER

DAS
26
9-89

Location

Loc Qty

Loc Code

GA

397

M129390

41

M132035

356

ST260a

2000

M134039

2000

ST263

1689

M134039

1689

ST269

1349

M130799

361

M132317

100

M132677

888

DAS
27
9-89

24x

DAS
28
9-89

MS21042L4

Purchased

No

110

Each

3,356.000

12

12

MS21042L 4

Locknut

DAS
26
9-89

Location

Loc Qty

Loc Code

FP001

41

m133363

41

GA

26

m127813

26

ST007

1500

m134055

1500

ST303

1692

m133769

1692

ST305

97

m130922

97

DAS
27
9-89

12x

DAS
28
9-89

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Work Order ID: 141157

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Parent Item: D206-642-312BL

***D206-642-312RI ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

D3407-043

Manufactured No

110 Each

12.0000

D3407-043

Tow Ring

**

1
B1403/6
DAS 26 9-89

Location

Loc Qty

Loc Code

st530

12

136685

10

136686

2

DAS 28 9-89

DAS

BLUE 27

D3456-1 9-89

Manufactured No

110 Each

125.0000

D3456-1

Washer

**

1

DAS 26 9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST038

118

136922

43

140756

75

DAS 28 9-89

DAS

27

9-89

D3457-1

Manufactured No

110 Each

66.0000

D3457-1

Washer

**

2

DAS 26 9-89

Location

Loc Qty

Loc Code

FG

10

32409

10

ST037

8

127393

8

ST038

4

136442

4

ST038A

44

138904

44

DAS 28 9-89

FEB 01 2016

DAS

27

9-89

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Work Order ID: 141157

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Parent Item: D206-642-312BL

***D206-642-312BL ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,034.000

1

1

MS21043-4

Nut

**

DAS
26
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	40	
104603	40	
GA	262	
m132803	262	
ST302	10	
m133316	10	
ST32	722	
m133769	722	

DAS
28
9-89

AN4C5A

Purchased

No

110

Each

80.0000

1

AN4C5A

Bolt

**

DAS
26
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

OVER002	50	
m133990	50	
ST345	30	
m132857	10	
m133135	20	

DAS
28
9-89

NAS1149C0463R

Purchased

No

110

Each

212.0000

1

NAS1149C0463R

Washer

**

DAS
26
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001	72	
m127306	72	
ST271	140	
m128401	40	
m133077	100	

DAS
28
9-89

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Work Order ID: 141157

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Parent Item: D206-642-312BL

***D206-642-312BI ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

D3413-1 Manufactured No

110 Each 21.0000

D3413-1

O-Ring

**

DAS
26
9-89

B 1/4/1552

DAS
27
9-89

BLUE

D2712

D2712

Set Screw

Manufactured No

110 Each 433.0000

**

DAS
26
9-89

10

Location

Loc Qty

Loc Code

st530

21

136462

21

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

55

29962

55

ST009

278

102226

12

135950

242

89929

10

93686

14

ST012a

100

140532

100

DAS
28
9-89

10x

D2934

Manufactured No

110 Each 42.0000

**

DAS
26
9-89

2

D2934

Saddle Spacer

Location

Loc Qty

Loc Code

FG

6

31929

6

ST014

36

136116

36

DAS
28
9-89

FEB 01 2016

2x

DAS
27
9-89

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Parent Item: D206-642-312BL

***D206-642-312BI ***

Parent Item Name: Skidtube RH, Low & High Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 1.00

Required Qty: 1.00

D2935

Manufactured No

110

Each

30.0000

2

2

D2935

Saddle Spacer

**

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

6

31793

6

ST014

24

136244

24

FEB 01 2016

DAS
27
9-89

DAS
28
9-89

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1	1	1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1	1	1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1	1	1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1	1	1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-11	WEARSHOE (REPLACES D3535-11 + D3536-11)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-35	WEARSHOE (REPLACES D3535-35 + D3536-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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